

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74271

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Page 2

Item ID: D4273-042

Accept

Revision ID:

Item Name: Basket Base Assembly, RH

Start Date: 9/27/2011 Start Qty: 1.00

Required Date: 10/4/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

S 11/10/11

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

1 BK 11-10-11

W/O:		WORK ORDER CHANGES					
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Work Order ID 74271



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Item ID:	D4273-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Base Assembly, RH					
Start Date:	9/27/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/4/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							IX ✓ M-L 11/10/05
M 118439	Memo	0.00							
	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT: 3:00								
	START TIME: 4:00 OF								
	OVEN TEMPERATURE: 400 OF								
	FINISH TIME: 3:30								
	*****2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
FINISH TIME: _____									
140  QC Quality Control	QC3- Inspect Part Finish	0.00							1 ✓ M-L 11/10/05
	Memo	0.00							

IX M-L 11/10/05

1 of 11/10/05

M 118439

3:00 400 OF
3:30

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

150

Identify as per dwg & Stock Location: 6A

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release


0.00

QC

Memo

0.00

Quality Control

11/10/12 
umf 11-10-11

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Picklist Print

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Page 1

Work Order ID: 74271

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 9/27/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC
 11.01.20 AS PER DWG REV.C DD verf:EC
 AS PER DWG REV.D DD verf:EC
 IPP Rev:B
 IPP Rev:C 11.03.03

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304EX0.75-16F

Purchased

No

100

sf

661.8659

26.195

26.195



Expanded Metal Flat SS



PL 11.10.3

Location

Loc Qty

Loc Code

WA

661.865935

115012

3.94

117197

102.9036

117455

16.0341

117896

53.3264

118153

82.2683

118248

33.0983

118450

0.013255

118597

83.28198

118955

287

26.195

D3913-1

Manufactured

No

100

Each

5.0000

1

1



Rib



PL 11.10.3

Location

Loc Qty

Loc Code

WA

3

59089

1

69260

2

WA006

2

73647

2

11

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Page 2

Work Order ID: 74271

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 9/27/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3



Rib

Manufactured No

100

Each

4.0000

1

1



Pl 11.10.03

Location

Loc Qty

Loc Code

WA

4

69160

1

73533

3

100

Each

4.0000

1

1



Pl 11.10.03

D3913-9



Hinge Rib

Manufactured No

Location

Loc Qty

Loc Code

WA

3

73530

3

WA006

1

70138

1

100

Each

3.0000

3

3



Pl 11.10.03

B73637 -> (3)

D3916-5



Light Rib

Manufactured No

Location

Loc Qty

Loc Code

WA

3

59088

3

100

Each

2.0000

1

1



Pl 11.10.03

B74077 -> (1)

D4017-7



Rib

Manufactured No

Location

Loc Qty

Loc Code

WA

1

69730

1

WA005

1

72964

1

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Shop Packet Print

Page 2

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Page 3

Work Order ID: 74271

Parent Item: D4273-042











Parent Item Name: Basket Base Assembly, RH

Start Date: 9/27/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

/ D4277-3	Manufactured	No	100	Each	0.0000	1	1	 B74275 → ① Pl 11.10.03
Rib								
/ D4277-5	Manufactured	No	100	Each	0.0000	2	2	 B74277 → 2 Pl 11.10.03
Rib								
/ D4277-9	Manufactured	No	100	Each	0.0000	1	1	 B74272 → ① Pl 11.10.03
Rib								
/ D4277-19	Manufactured	No	100	Each	0.0000	1	1	 B74285 → ① Pl 11.10.03
Rib								
/ D4278-041	Manufactured	No	100	Each	0.0000	1	1	 B74292 → ① Pl 11.10.03
Upper Rib Assembly-Hoop								
/ D4278-045	Manufactured	No	100	Each	0.0000	2	2	 B74291 → ② Pl 11.10.03
Rib Assembly, Fwd Cham								
/ D4278-047	Manufactured	No	100	Each	0.0000	1	1	 B74288 → ① Pl 11.10.03
Upper Rib Assembly-Straight								
/ D4306-1	Manufactured	No	100	Each	0.0000	1	1	 B74278 → ① Pl 11.10.03
Rib								
/ D4306-044	Manufactured	No	100	Each	0.0000	1	1	 B74290 → ① Pl 11.10.03
Rib Assembly, RH								
/ D4306-045	Manufactured	No	100	Each	0.0000	1	1	 B74289 → ① Pl 11.10.03
Rib Assembly								

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Shop Packet Print

Page 3

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Picklist Print

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Page 4

Work Order ID: 74271

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 9/27/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

24.0000

2

2



Mounting Bracket



PL 11.10.3

Location

Loc Qty

Loc Code

WA

24

69739

2

70766

2

73079

20

D3913-15

Manufactured No

100

Each

3.0000

1

1



Wide Handle Plate



PL 11.10.3

Location

Loc Qty

Loc Code

WA005

3

69012

1

72550

2

D4016-1

Manufactured No

100

Each

19.0000

3

3



Hinge Half, Base



PL 11.10.3

Location

Loc Qty

Loc Code

WA

19

66418

0

68426

3

72757

16

D4021-1

Manufactured No

100

Each

18.0000

3

3



Handle Plate



PL 11.10.3

Location

Loc Qty

Loc Code

WA

6

69518

6

WA005

12

73649

12

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Page 4

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 5

Work Order ID: 74271

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 9/27/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

D4279-3 Manufactured No

100

Each

0.0000

1 1



Mesh, Chamfer

D4279-5 Manufactured No

100

Each

6.0000

1 1



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

6

73270

6

D4279-7 Manufactured No

100

Each

0.0000

2 2



End Mesh, Basket

D4279-9 Manufactured No

100

Each

6.0000

1 1



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

6

63790

1

73265

5

D4279-11 Manufactured No

100

Each

0.0000

1 1



Mesh, Base

374283 → ① 6/11/10/03

373270 → ① 6/11/10/03

374284 → ② 6/11/10/03

6/11/10/03

374286 → ① 6/11/10/03

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

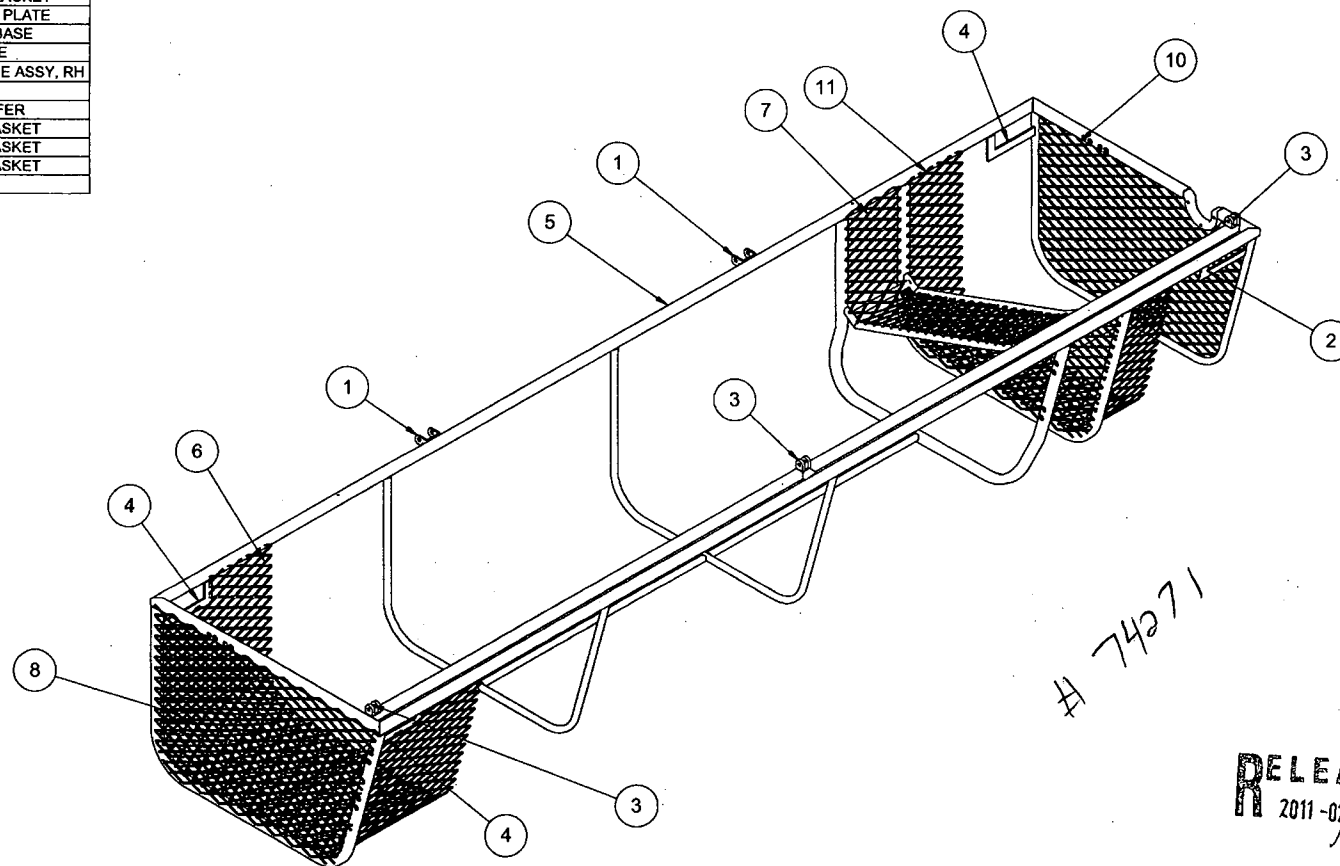
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NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D4273	SHEET 6 OF 10
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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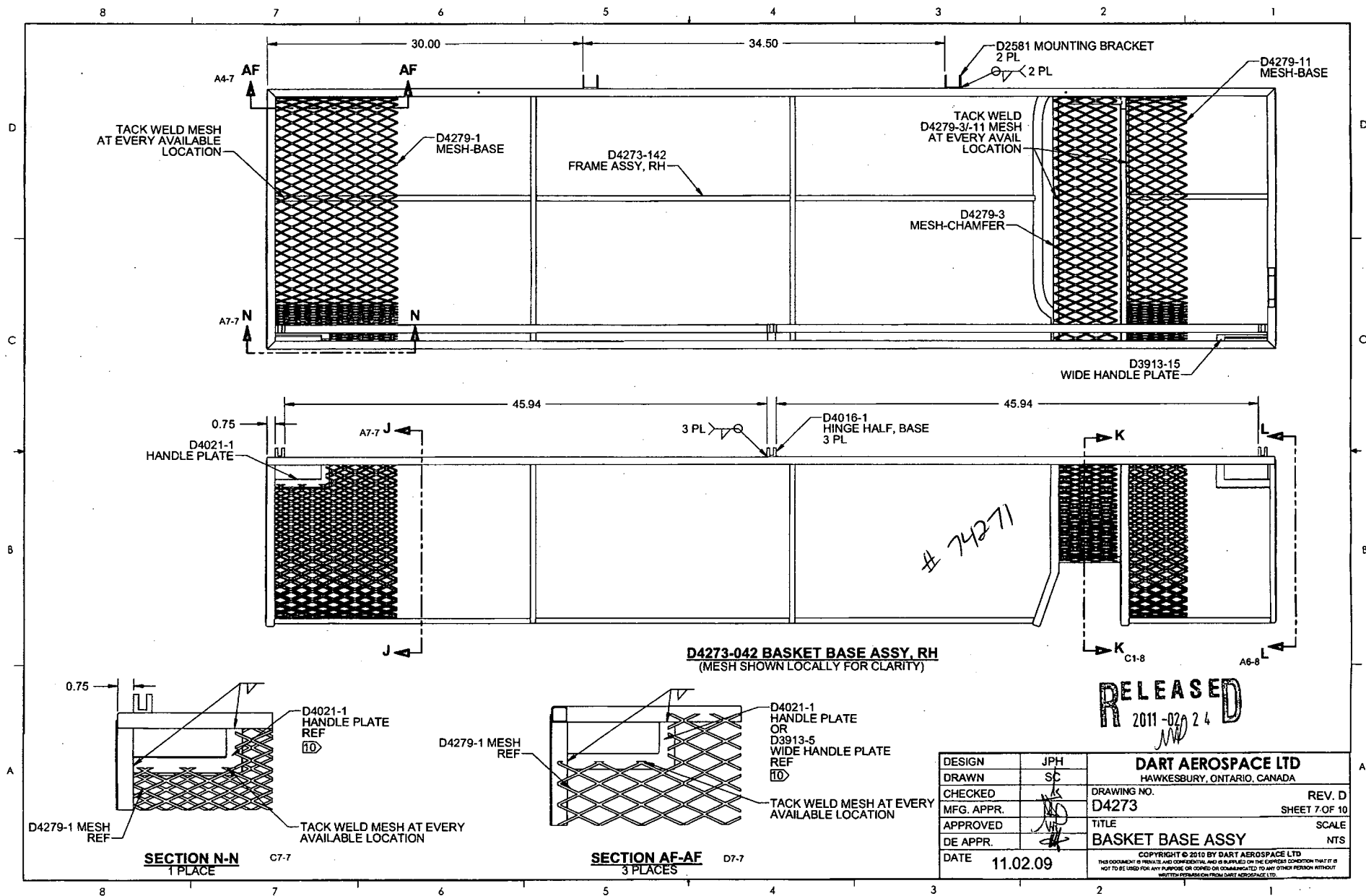
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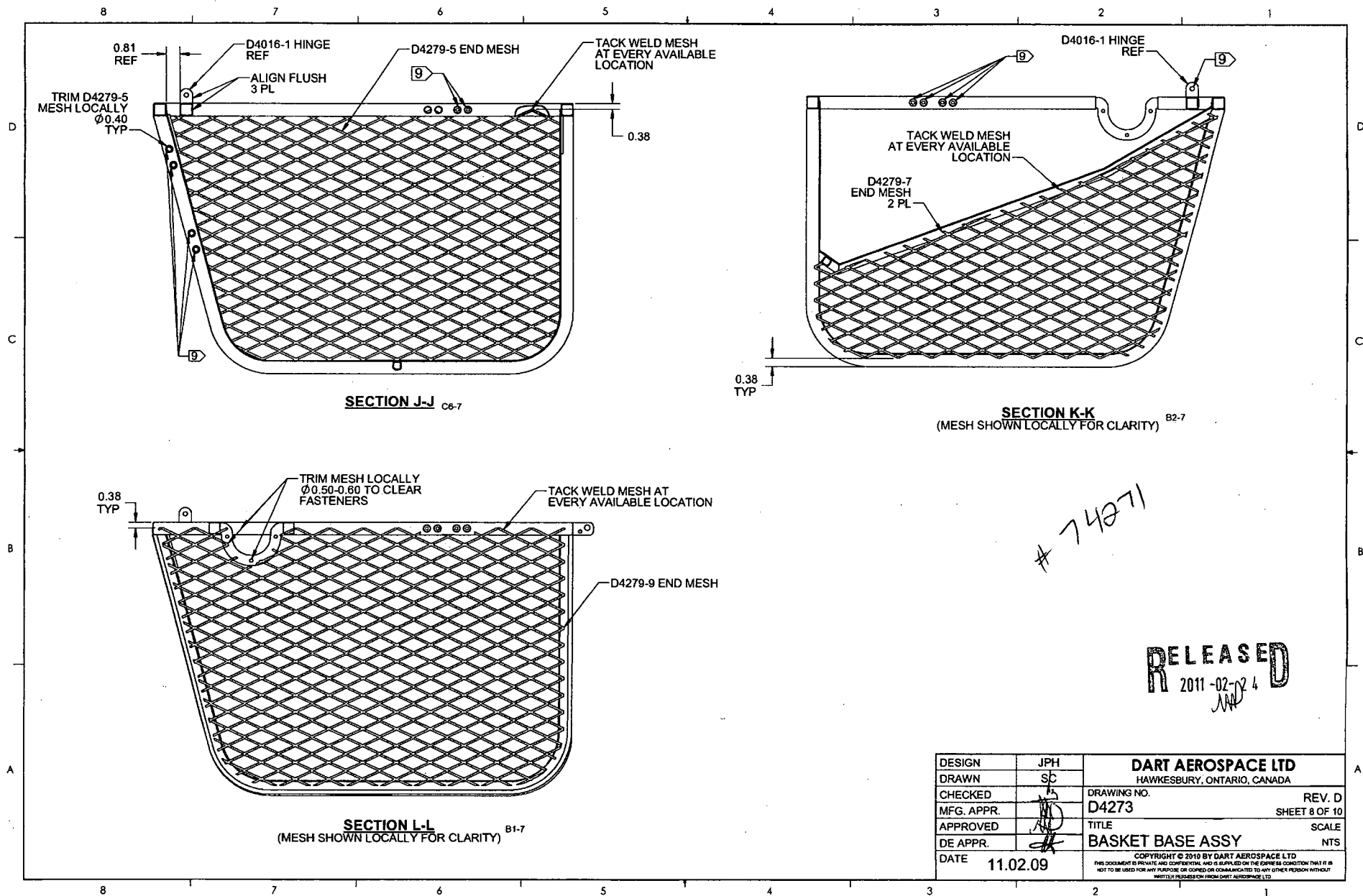
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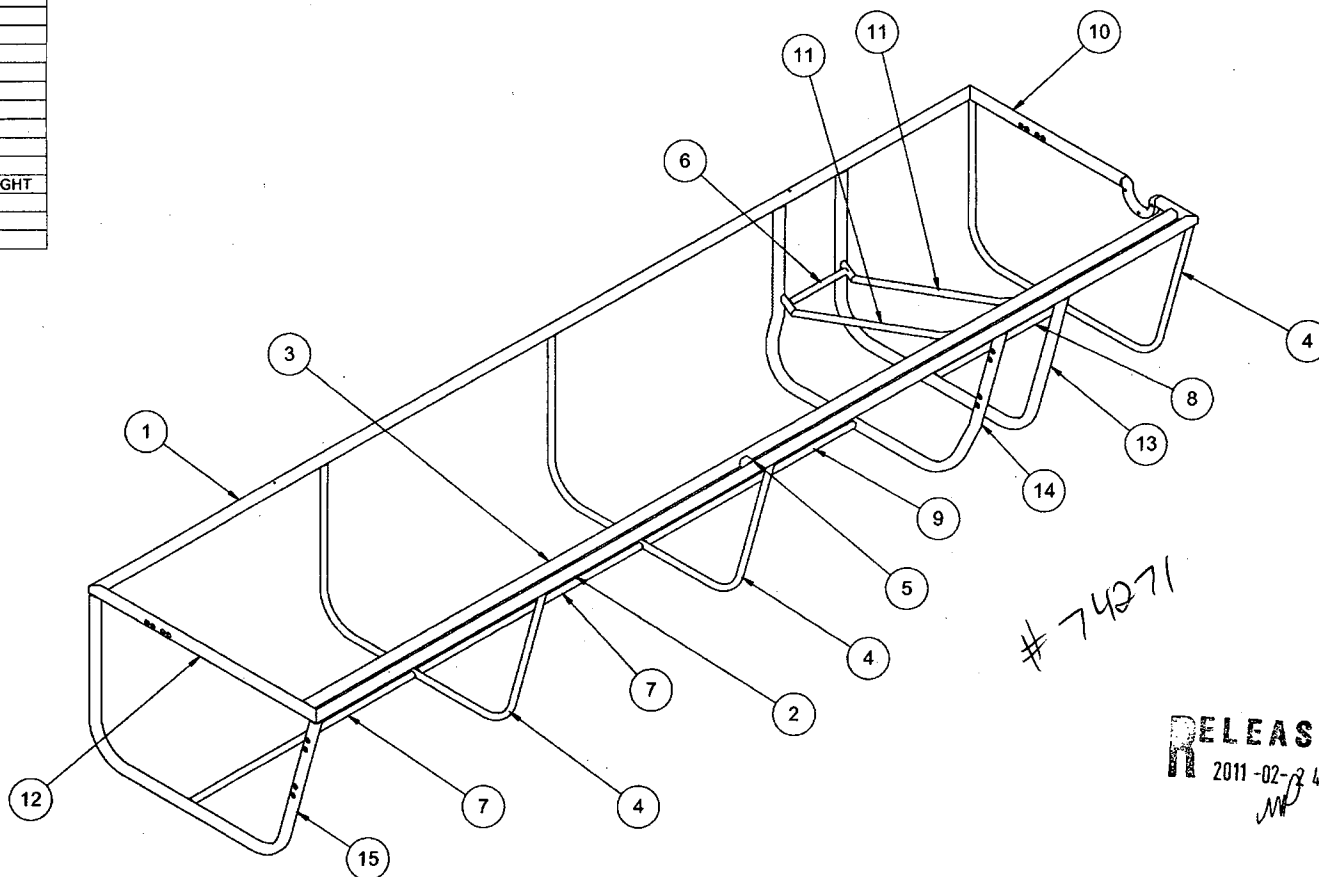
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY



#74271

RELEASED
2011-02-24
MB

D4273-142 BASKET FRAME ASSY, RH

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	MS	D4273	SHEET 9 OF 10
APPROVED	AWP	TITLE	SCALE
DE APPR.	AWP	BASKET BASE ASSY	NTS
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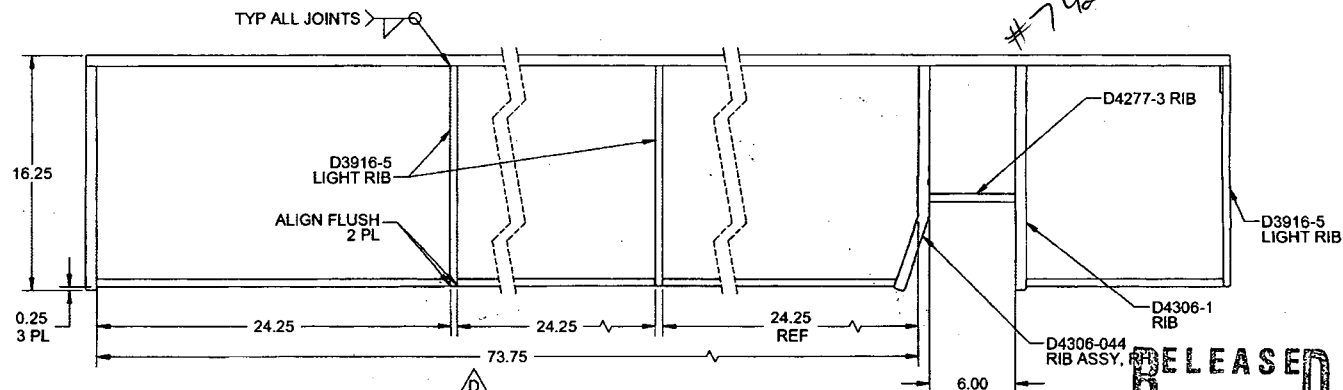
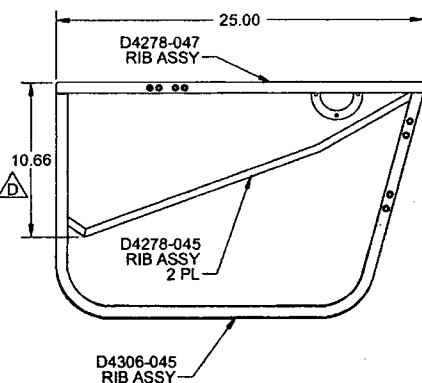
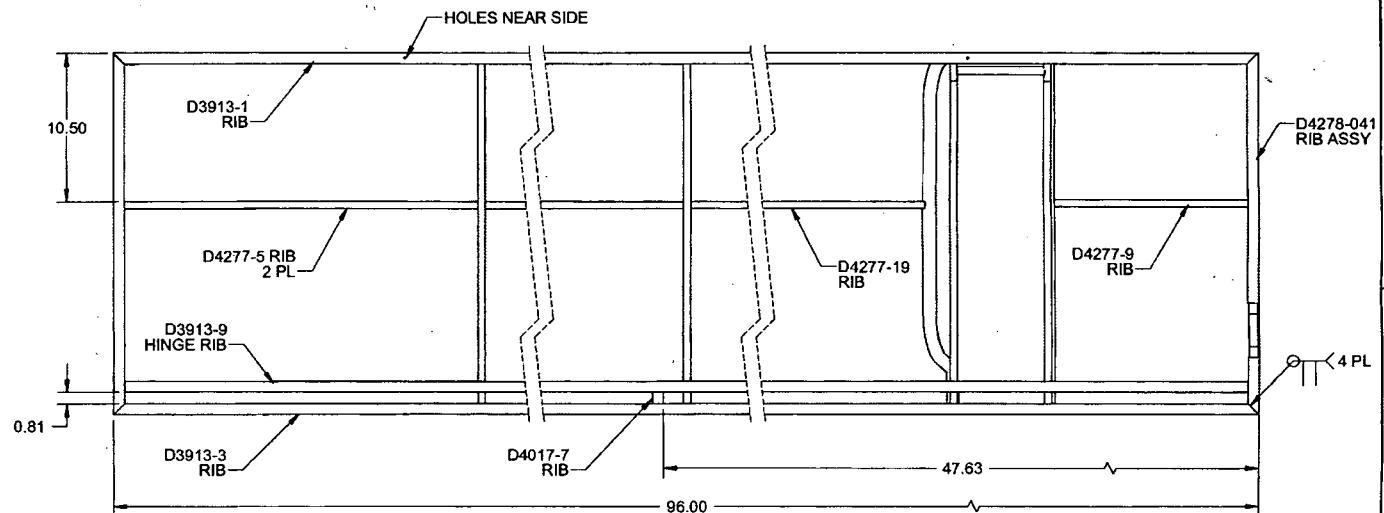
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D4273-142 BASKET FRAME ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 24.77 lbs
- 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4273	SHEET 10 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSY	NTS
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R 2011-02-24

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